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D3912-1
Job Sheet 186906



Part No: D3912-1

Job Qty: 10 ea

Part Name: Eyebolt



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Machining-2		 18/12/18 6 DEC 05 2018
100	Doosan	10 pcs	12/7/18	12/7/18	0.00	7.14	Doosan		
110	QC	10 pcs	12/7/18	12/7/18	0.00	0.00	QC2 Machining-2		
120	QC	10 pcs	12/7/18	12/7/18	0.00	0.00	QC8 Machining-2		
130	Packaging	10 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2	54056	
140	QC21-SA	10 Ea	12/7/18	12/7/18	0.00	0.00	QC21		DEC 05 2018
Part Op Descriptions: 100 - TURN AS PER FOLIO FA871AND DWG Prog Rev: _____ Deburr as required									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	2.8000 ft (.28 ea) 2.329	90-Start up Operation	5018010 35 3/4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	3	21	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt	0.130Inches ± 0.030	0.160 0.100	.130	
2	Eyebolt	0.700Inches ± 0.010	0.710 0.690	.7	
3	Eyebolt	0.500Inches ± 0.010	0.510 0.490	.5	
4	Eyebolt	0.900Inches ± 0.030	0.930 0.870	.8995	
5	Eyebolt	0.130Inches ± 0.030	0.160 0.100	.138	
6	Eyebolt	45.0Degrees ± 0.5	45.5 44.5	45°	
7	Eyebolt	0.220Inches ± 0.030	0.250	.222	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

			0.190	
8	Eyebolt	0.750Inches ± 0.030	0.780 0.720	.752
9	Eyebolt	0.970Inches ± 0.010	0.980 0.960	.97
10	Eyebolt	1.720Inches ± 0.030	1.750 1.690	1.7205
11	Eyebolt	1.200Inches ± 0.030	1.230 1.170	1.199
12	Eyebolt	0.6250Inches ± 0.0100	0.6350 0.6150	.627
13	Eyebolt	2.230Inches ± 0.030	2.260 2.200	2.228
14	Eyebolt	0.130Inches ± 0.030	0.160 0.100	Radius $\frac{1}{8}$
15	Eyebolt	0.015Inches ± 0.010	0.025 0.005	Radius .015
16	Eyebolt	0.625Inches ± 0.010	0.635 0.615	.626
17	Eyebolt	0.650Inches ± 0.010	0.660 0.640	.648
18	Eyebolt	1.100Inches ± 0.010	1.110 1.090	1.1
19	Eyebolt	0.440Inches ± 0.030	0.470 0.410	.4415
20	Eyebolt	0.130Inches ± 0.030	0.160 0.100	Radius $\frac{1}{8}$
21	Eyebolt	1.000Inches ± 0.030	1.030 0.970	1.003
22	Eyebolt	0.250Inches ± 0.030	0.280 0.220	.2515
23	Eyebolt	0.880Inches ± 0.030	0.910 0.850	.884
24	Eyebolt	0.110Inches ± 0.030	0.140 0.080	.109
25	Eyebolt	0.719Inches + 0.010 - 0.000	0.729 0.719	.7245

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
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FAULT CATEGORY ☐ Effect ☐ Late/Unqualified ☐ Complete/Unclear ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence

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Container No: S134622



Part: D3912-1

Job No: 186906

Serial No/Batch: S134622

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/04/18

Misidentified ☐

Past Due ☐

OTHER : _____